

42
DART AEROSPACE LTD.

Work Order : 21452

Description: 206 Saddle, Outboard, Left Side

Part Number: D2665-1

Drawing: D2665 Rev B

Qty: 8

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order DWG. not required RF 02/09/16	JH	04.09.03	8
2	STORES	Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length (D6101-003) RF 02/09/16 Batch No: B70982B	EP	05/02/03	8
3	HAAS	Program batch number.	EP	05/02/03	8
4	QC	Inspect part number and batch number are programmed correctly.	EP	05/02/03	8
5	HAAS	Fixture W/O No. N/A Fixture Inspection last completed on 05/02/03 by EP	EP	05/02/03	8
8	HAAS	Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	EP	05/02/03	8
9	HAAS	Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	EP	05/02/03	8
10	HAAS	Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	EP	05/02/03	8
11	LAGUN	Machine Keyway and inspect per attached dimension sheet	EP	05/02/03	8
12	METAL	Deburr	EP	05/02/03	8
13	HAAS	Inspect Level 1	EP	05/02/03	8
14	QC	Inspect Level 8	EP	05/02/03	8
15	METAL	Acid etch and Alodine as per QSI 005 4.1	EP	05/02/03	8
16	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.1	EP	05/02/03	8
17	QC	Inspect Level 3	EP	05/02/03	8
18	STORES	Pack in foam, identify and stock.	EP	05/02/03	8
19	EXPEDITING	Close Work Order Job Cost / Part 92.70 Sur 05/02/29 (8) 89.54	JH	05.08.03	8

Rev	Date	Change	Revised By	Approved
A	97.07.24			
B	98.09.02	Inspection Levels, Added Powder Coat	KS	
C	00.11.01	Removed P/O for Powder Coat – in house process	EC	

RELEASED

EC DEC 18 2000

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-COMFORMANCE							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
05/02/10	#9	First run scrap. wrong B/A4 offset.	M	destroy & replace	EJ 05/02/10	JL 05.02.10	WD 05/02/10	W.D. 05/02/10	B 05/02/10

PAR#: N/A

Fault Category: U/A

DQA: SP

Date: 05/03/10

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Part Number:

D2665-1

Inspection Dwg: D2665 Rev. B

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Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.133	0.134	0.131	0.133		
B	0.100	0.140		0.132	0.136	0.132	0.131		
C	0.100	0.140		0.129	0.133	0.126	0.125		
D	0.210	0.230		0.225	0.225	0.223	0.229		
E	1.245	1.255		1.248	1.249	1.248	1.248		
F	1.245	1.255		1.248	1.249	1.248	1.248		
G	5.990	6.010		6.001	6.002	6.001	6.003		
H	0.510	0.515		0.500	0.510	0.500	0.500		
I	1.674	1.684		1.679	1.678	1.679	1.680		
J	2.495	2.505		2.499	2.500	2.500	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		0.235	0.235	0.235	0.236		
N	0.100	0.140		0.122	0.128	0.119	0.115		
O	0.540	0.560		0.546	0.540	0.543	0.545		
P	0.490	0.510		0.500	0.494	0.498	0.499		
Q	3.609	3.619		3.612	3.612	3.614	3.614		
R	2.470	2.510		2.501	2.504	2.502	2.502		
S	0.240	0.270		0.258	0.256	0.257	0.253		
T	0.100	0.180		0.135	0.150	0.135	0.135		
U	0.313	0.318	DT8686	/	/	/	/		
V	1.125	1.145		1.132	1.130	1.135	1.134		
W	1.565	1.585		1.570	1.569	1.567	1.574		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SP
Date: 05/02/11Audited by: gml
Date: 05/02/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF RF	#

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				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.131	0.131	0.134	0.134		
B	0.100	0.140		0.131	0.132	0.132	0.132		
C	0.100	0.140		0.127	0.125	0.125	0.126		
D	0.210	0.230		0.224	0.222	0.223	0.226		
E	1.245	1.255		1.245	1.245	1.250	1.248		
F	1.245	1.255		1.245	1.245	1.250	1.248		
G	5.990	6.010		5.999	6.006	6.002	5.999		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.674	1.684		1.680	1.686	1.680	1.680		
J	2.495	2.505		2.503	2.501	2.499	2.497		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.235	0.235	0.235	0.235		
N	0.100	0.140		0.121	0.121	0.121	0.123		
O	0.540	0.560		0.544	0.544	0.545	0.545		
P	0.490	0.510		0.499	0.495	0.502	0.501		
Q	3.609	3.619		3.613	3.612	3.612	3.612		
R	2.470	2.510		2.503	2.501	2.502	2.498		
S	0.240	0.270		0.256	0.254	0.256	0.256		
T	0.100	0.180		0.139	0.135	0.138	0.135		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.133	1.133	1.133	1.134		
W	1.565	1.585		1.571	1.571	1.571	1.573		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: *EP*
Date: *05/02/10*Audited by: *anl*
Date: *05/02/11*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF <i>RF</i>	#

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 03, 2004
11:45 am

Work Order No : 0021452
 Project Name : D2665-1
 Project For : WK442
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2665-1
 Description : Saddle, LH Fwd Aft Out
 Manufactured : Yes
 Amount Req'd : 8
 Amount Done : 0
 Start Date : 09-03-04
 Est Finish Date : 10-14-04
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss)	0.00	0.00